Date: User:

Monday, 07/07/2008 4:23:04 PM

Julie Lecocq

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number

: 40342

**Estimate Number** 

: 10383

P.O. Number

This Issue : 07/07/2008

Prsht Rev.

: NC

: // First Issue : 39261

**Previous Run** 

Written By

**Checked & Approved By** 

Comment

Now M6061-T6 06-06-23 JLM Est Rev:B

: SMALL /MED FAB

**Additional Product** 

Job Number:

Seq. #:

1.0

**Machine Or Operation:** 

M6061T6S080

Comment: Qty.:

0.0992 sf(s)/Unit

Total:

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: 108433

WATER JET 2.0

Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: 8

Prog Rev: B

08 07 09

9.9225 sf(s)

2-Deburr if necessary

3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

HAND FINISHING RESOUR

Comment: SECOND CHECK

5.0

HAND FINISHING1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

**Drawing Number** : N/A Project Number **Drawing Revision** : B

Material

**Drawing Name** 

**Part Number** 

Description:

6061-T6 .080 Sheet

: 25/07/2008 **Due Date** 

: SPACER

: D30661

: D3066 REV.B

Qty:

100 Um:

Each









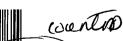
























Dart Ae	rospace Lt	d									
W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE			PROCEDURE CHANGE By Date Qty		By Date Qty	e Qty Apr	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>			<del></del>								
					1						
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date:				
				QA	: N/C Close	d:	_ Date: _				
NCR:		\	WORK ORDER NON-CON	IFORMANCE (N	CR)						
	1		Corrective Actio	n Section B							

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
							-	
						-  -  -		
			;					

NOTE: Date & initial all entries

Monday, 07/07/2008 4:23:04 PM Date: Julie Lecocq User: , **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 40342 Part Number: D30661 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE W 8807.18 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		· · · · · · · · · · · · · · · · · · ·							

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	
			QA: N/C	Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Ammerical	Ammanal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
						:	į		
								}	
I I									

NOTE: Date & initial all entries

Work Order:	40342
Part Number:	D3066-1
	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	0.129	V		Vern	
0.708	+/-0.010	0.698	<b>V</b>		ver.N	
<del>0.35</del> 8 0.354	+/0.010	0.348	J		Vern	
-0.350 0.354	+/0.010	0.356	V		vern	
2.250 (Pitch)	+/-0.005	2.254			ver	
16.450	+/0.010	16.450	<i>V</i>	_	M.T	

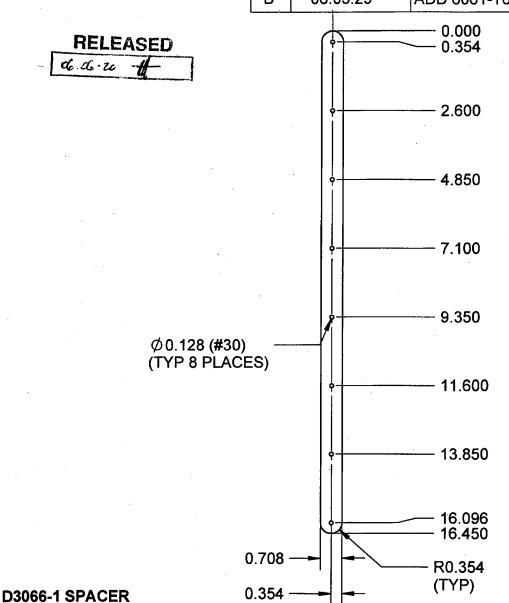
			<u> </u>		
Measured by:	M.M	Audited by:		Prototype Approval:	N/A
Date:	08 07 09	Date:	02/07/14	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	03.09.22	New Issue	P/O D3065-041	KJ/RF	
В.	06.06.23	Dwg Rev. changed		KJ/JLM o	<i>S</i> ##





DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED. DRAWING NO. CHECKED REV. B D3066 SHEET 1 OF 1 TITLE DATE **SCALE** 06.05.29 **SPACER** 1:3 02.09.11 Α **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL



1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK COPY (REF DART SPEC M6061T6S.080) **ENGINEERING** 

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK UNCONTROLLED COPY (REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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